

Work Order ID 78306

January-05-12 8:30:28 AM

\*78306\*

Page 1

Item ID: D2282-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: T Assembly

Start Date: 05/01/2012 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 12/01/05 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly  
Grind chamfers and ensure full penetration as per dwg D2282  
\*\*\*\*\*brush weld right after welding, to take color off\*\*\*\*\*  
A/RER316L SS Filling Rod 120013

110

0.00

\*110\*

QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

Quality Control

120

0.00

\*120\*

Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

12-02-23 50x

12-02-24

50x

12-2-24 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78306

**\*78306\***

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January-05-12 8:30:28 AM

Item ID: D2282-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: T Assembly  
 Start Date: 05/01/2012 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 23/03/2012 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC5- Inspect part completeness to step on W/O 0.00

**\*130\***  
QC

Quality Control

Memo

0.00

*6.26 hrs*

*auto*  
*XS*

140 Identify as per dwg & Stock Location *G.A* 0.00

**\*140\***  
Packaging

Packaging

Memo

0.00

*12/03/13* *50*

150 QC21- Final Inspection - Work Order Release 0.00

**\*150\***  
QC

Quality Control

Memo

0.00

*12/13/14*

*12-03-13*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

January-05-12 8:30:32 AM

Page 1

Work Order ID: 78306

\*78306\*

Parent Item: D2282-041

\*D2282-041\*

Parent Item Name: T Assembly

Start Date: 05/01/2012

Required Date: 23/03/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3		Manufactured	No			100	Each	38.0000	1	50			
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\*D2282-3\*

Tube

\*\*

B 78313 → 23x

Location

Loc Qty

Loc Code

WA019

38

74969

38

27x

12.02.23

D2282-5

Manufactured No

100

Each

38.0000

1

50

\*D2282-5\*

Tube

\*\*

B 78312 → 23x

Location

Loc Qty

Loc Code

WA020

38

74962

38

27x

12.02.23

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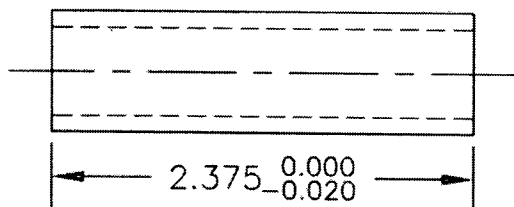
**NOTE:** Date & initial all entries



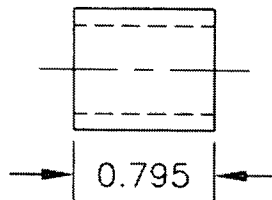
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED  
*[Signature]*

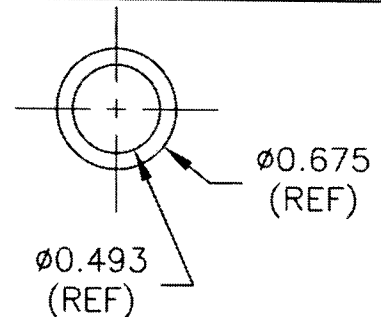
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**D2282-3**

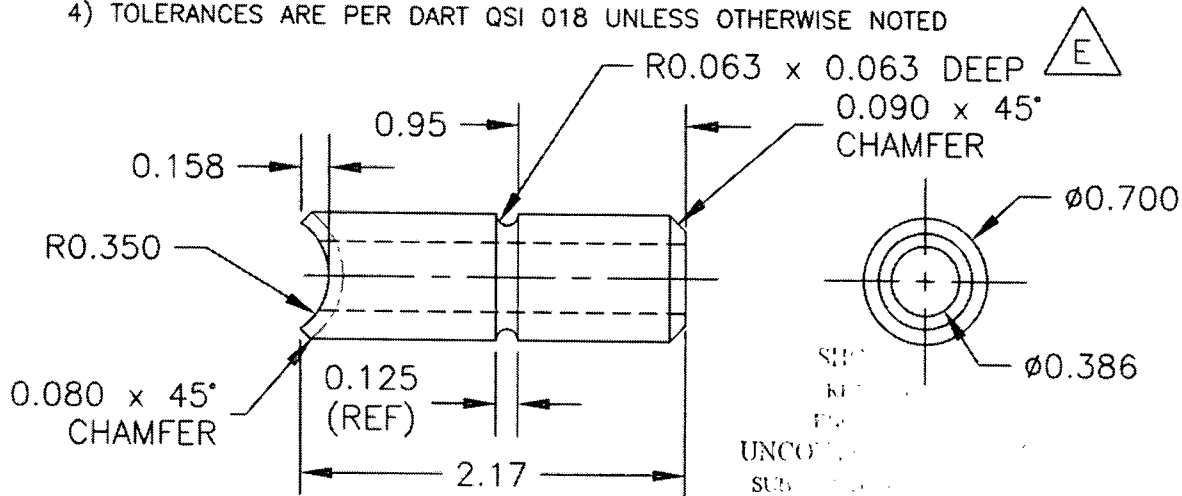


**D2282-7**



**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D2282-5**

**D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 7-8306 M.C.J.  
12/01/05



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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

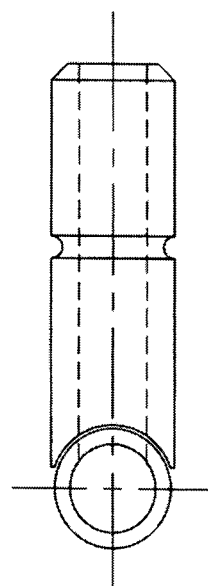
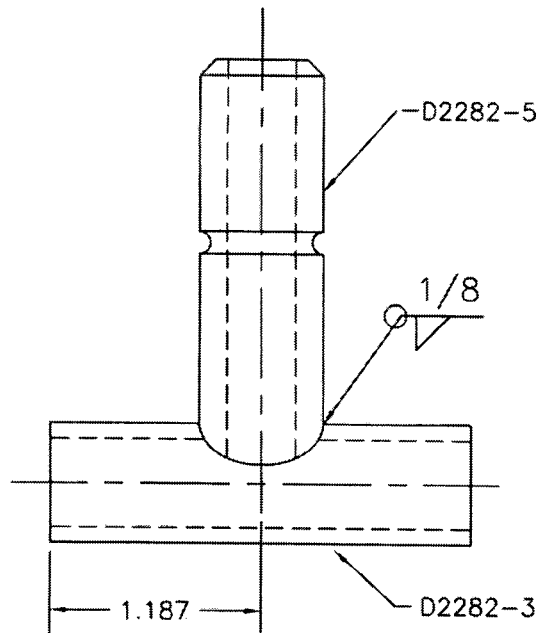
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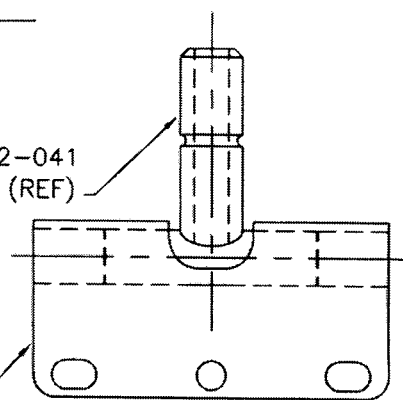




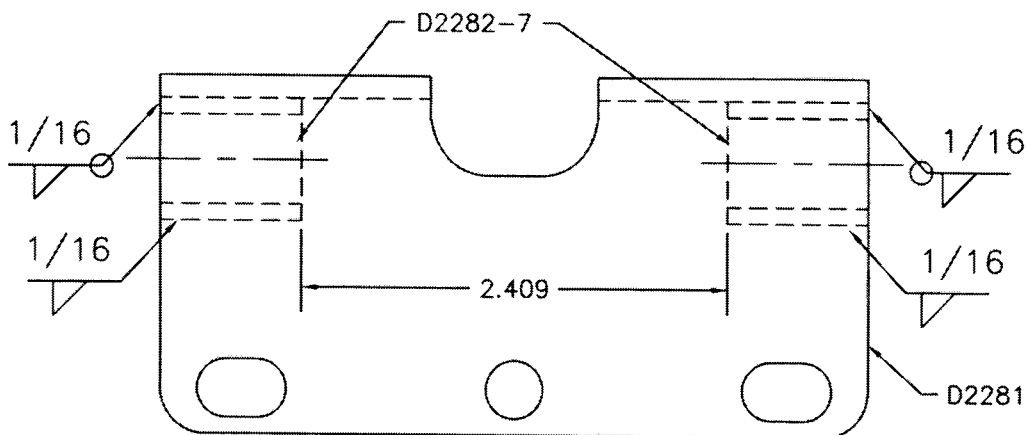
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041  
(REF)



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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